

Work Order ID 80345

February-17-12 8:35:09 AM

80345

Page 1

ASAP

Item ID: D3552-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Prop

Start Date: 17/02/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 24/02/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3552

J

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 16217

Purchase Part Number: B8-240-575-150N

Supplier: LS Technologies

Certificate of conformity is required

12-02-17 (24)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

12-02-22 (24)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Test for correct pressure

12-02-22 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *Z72*

0.00

130

Packaging

Memo

0.00

Packaging

12/2/22 *24*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

M.C.J *12/02/23*

12-02-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

February-17-12 8:35:13 AM

Page 1

Work Order ID: 80345

80345

Parent Item: D3552-11

D3552-11

Parent Item Name: Door Prop

Start Date: 17/02/2012

Required Date: 24/02/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC IPP Rev:C
as per dwg RevE DD 10.02.17 verified by:EC IPP Rev:D 10.12.03 as
per dwg rev.G DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

B8-240-575-150N

Purchased

No

110

Each

0.0000

1

24

B8-240-575-150N

**

GAS SPRING

17/2/22 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

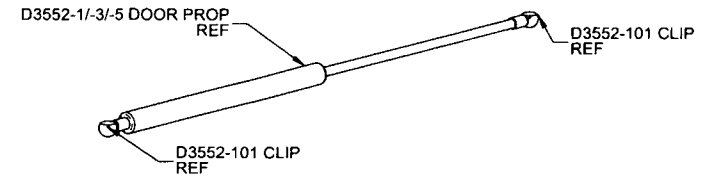
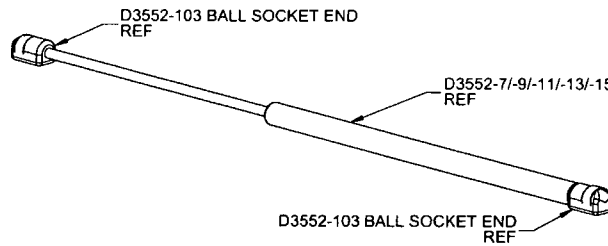
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



RELEASED
2011-12-13

UNCONTROLLED COPY
SUBJECT TO APPROVAL
WORK ORDER
NO. 80345 M.C.J
12/02/17

J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 139/6.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE 300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 180/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-8; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO. D3552	REV. J
MFG. APPR.		TITLE DOOR PROP	SHEET 1 OF 2
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.12.07		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

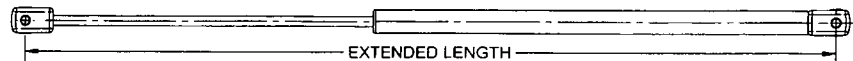
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

80345



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N
D3552-15	DOOR PROP	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N
D3552-17	DOOR PROP	154/6.06	387/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N
D3552-19	DOOR PROP	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300N
D3552-27	DOOR PROP	148/5.83	475/18.7	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-156N
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9

J

J

2

3

D3552-X DOOR PROP

RELEASED
2011-12-13

NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27 DOOR PROPS
- 3) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. J
MFG. APPR.		D3552	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOOR PROP	NTS
DATE	11.12.07	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16217**

Purchase Order Date 2/17/2012

PO Print Date 2/17/2012

Page Number 1 of 1

Order From : VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	306 683 5000	Requisition Nbr	
Vendor Fax	306 683 6403	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B8-240-575-150N	GAS SPRING	2/15/2012 Yes	24.00 Each	FedEx PI collect	\$41.3640	\$992.74
		Special Inst:	AS PER DWG: D3552 REV: J B80345				
2	B8-154-387-300N	Gas Spring	2/15/2012 Yes	6.00 Each	FedEx PI collect	\$26.5000	\$159.00
		Special Inst:	AS PER DWG: D3552 REV: J B80346				
3	B6-190-475-070N	Door Prop	2/15/2012 Yes	12.00 Each	FedEx PI collect	\$32.5000	\$390.00
		Special Inst:	AS PER DWG: D3552 REV: J B80347				

PO Total: \$1,541.74

Change Nbr: 2

Change Date: 2/17/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

314 Jessop Ave
Saskatoon, SK S7N 1Y6

P.O. No.	Date	Invoice #
16217	17/02/2012	8274

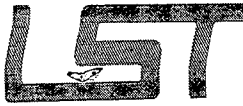
Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
17/02/2012	Fed-Ex	

Qty	Description
24	B8-240-575-150N Gas spring
6	B8-154-387-300N Gas Spring
12	B6-190-475-070N Gas Spring
	Shipping Via FED EX Tracking # 798073727926





LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

Feb 17, 2012

24 Units: B8-240-575-150N Carbon Steel Gas Spring

6 Units: B8-154-387-300N Carbon Steel Gas Spring

12 Units: B6-190-475-070N Carbon Steel Gas Spring

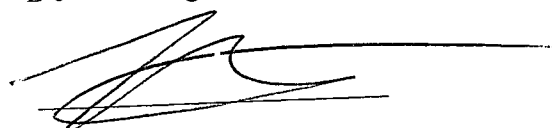
Country of Manufacture: Canada

Date of Manufacture : Feb 2012

This product is ROHS compliant.

Purchase Order # 16217
Invoice # 8274

L S Technologies Inc Canada



Nolan Fehr
Manager